

Process Sheet

Split SP 07/12/18

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CLAMP
Job Number	32016-B	Part Number	D2438
Estimate Number	10267	Drawing Number	D2438 REV. C
P.O. Number	N/A	Project Number	N/A
This Issue	4/23/2007	Drawing Revision	C
First Rev.	NC	Material	N/A
First Issue	N/A	Due Date	6/15/2007
Previous Run	30631	Qty:	200
Time in By		Um:	Each
Checked & Approved By			
Comment	Est: E 05/06/28 Bending removed KJ/JLM		

Additional Product:

Number:



Seq. #	Machine Or Operation:	Description:
10	16 PURCHASING	
	Comment: PURCHASING Issue P/O: 3619 Laser cut as per Dwg D2438 Material release note is required	 C. 6/10/14 200 Laser cut + formed
20	D2438B Clamp	
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s) CLAMP	
30	PACKAGING 1	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	 7/12/14 50 200
40	006 DIMENSIONAL CHECK	
	Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2438 (6.786" center to center)	 Z 6/12/14 100
50	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & Deburr any rough edges	 MF 07-12-19 +20 1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 32016

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0 CC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/19 (1)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

12/12/19 (1)

8.0 CC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/12/20 (1)

Completion



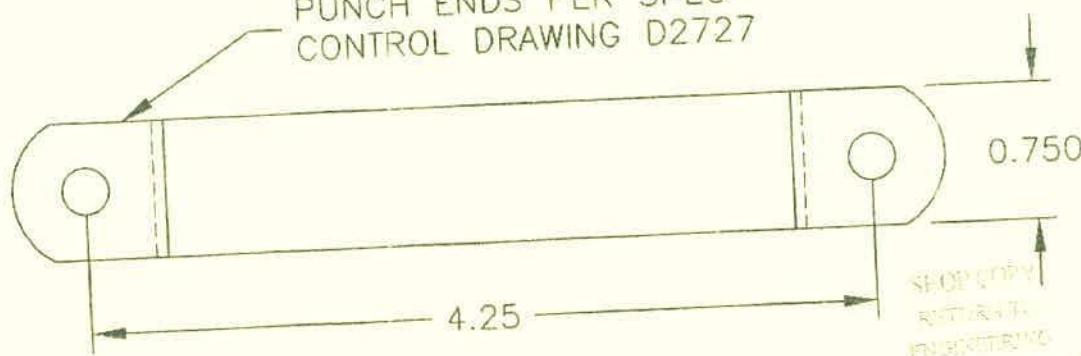
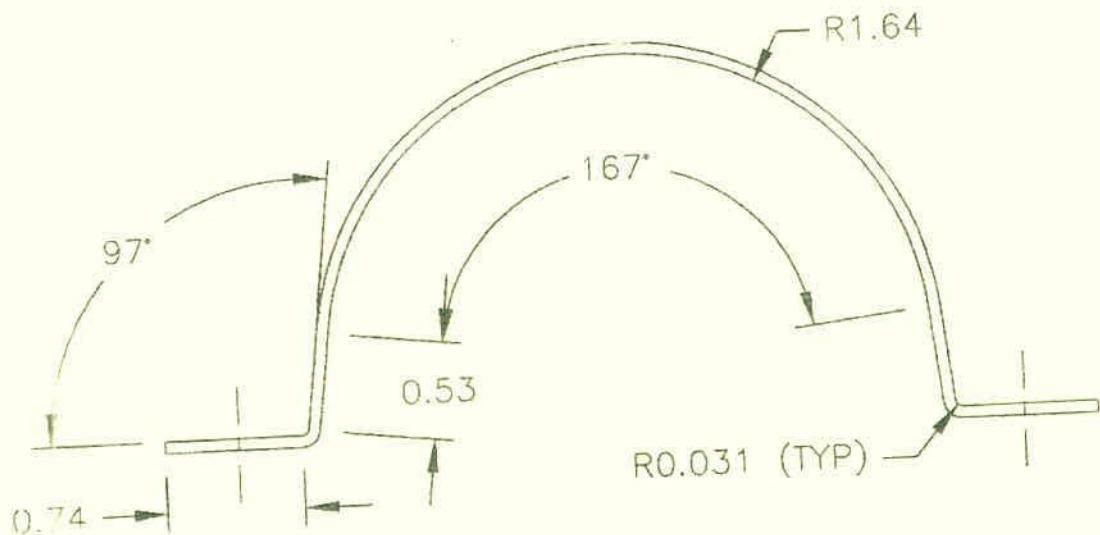
u 07/12/19

DART

COPY ISSUED
BY
D

DESIGN CHECKED DATE	DRAWN BY APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
98.05.12		DRAWING NO. D2438
		REV. C SHEET 1 OF 1
		SCALE 1:1
A	96.01.24	NEW ISSUE
B	96.05.13	CHANGE LENGTH
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY

RELEASED
49.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

SHOP COPY
RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32016

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

#000606
CP000007

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

ITEM NO.	12	OUR JOB NO.	50172854	SHIPPING MEMO	0381158
NOTE	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
31 PCS	PO00003619	D2438B	C	CLAMP	C
MATERIAL	SUPPLIED BY			MAT. REL. NO.	
ST 304	TW METALS / NORTH AMERICAN			1XL6	
PROCESS	PROCESSOR			RELEASE NO. -	
ARTICLE INSPECTION REPORT ON FILE	GFI			CONFORMS	

I CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIALS SUPPLIED
AS INDICATED ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORMED TO THE
PARTS AND PURCHASE ORDER REFERENCED ABOVE.

DATE: 15 DECEMBER 2007

G.F.I. Q.C. REP. Master Rep

Ref: 204 LAN 004 ARNS 0013/0521
 Customer: TW METALS INC.
 Heat: 1XL6
 Shipped: 05/3/07

Ref: X 120
 P.O: 09175261
 Sales: 01004150
 QTY: 53

FERGUSON METALS, INC.
 This is to certify that in accordance with the
 records in our files the material shipped on your
 purchase order conforms to the following:
 3475 Symmes Road
 Hamilton, OH 45011

Authorized Signature
 Lynn R. Harder
 President



NORTH AMERICAN
 STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
 Ghent, KY 41045-9615
 (502) 347-6800

Certificate: 357787 02

Mail To:
 FERGUSON METALS INC.
 3475 SYMMES ROAD
 HAMILTON, OH 45011

Ship To:
 FERGUSON METALS INC.
 3475 SYMMES ROAD
 HAMILTON, OH 45011

Date: 5/02/2007 Page: 1

Customer: 0018 001

Steel: 304/304L

Your Order: 01009705

NAS Order: AN 0366117 02

Finish: 2B

Corrosion: ASTM A263/02mn/1803mn-OK

PRODUCT DESCRIPTION

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED,

ASTMA240/06b, 480/06b, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04

QQ-S766D-A YM6YRM, RM85511H/5513H YM85511H, MIL4043B, AND3, XCRNMHE3&VN

REMARKS:

Mat'l free of Ni content. No weld repairs. RoHS-Compliant.
 EN 10204 3.1 PED 97/23/EC Annex, Para. 4.3 QQ-S766D Cond A
 "Melted & Manufactured in the USA"

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
021XL6 A	021XL6 A	.0520	48.0000	10,350 COIL	992.80	11	1	

CHEMICAL ANALYSIS

Heat	CM	C	CR	CU	NH	MO	S	NT	P	S	SI
1XL6	US	.022	18.335	.396	1.815	.323	.096	9.616	.030	.010	.160

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i o r	UTS ksi	.2% VS ksi	ELONG % 2"	Hard RB	Hard Rock
021XL6 A	021XL6		F T	91.80	45.40	46.22	83.00

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

REVIEWED BY Q.C.
 Date 5/4/07 by L

ERIC HESS

5/02/2007

